

OPTIONAL INFORMATION	
Name of School:	Date of Inspection:
Vocational Program/Course/Room:	Signature of Inspector:

## BAKERY FLOUR-HANDLING EQUIPMENT AND OVENS SELF INSPECTION CHECKLIST

**Guidelines:** This checklist covers some of the regulations issued by the U.S. Department of Labor - OSHA under the General Industry standard 29 CFR 1910.263 which was adopted by reference. The requirements of this checklist apply to the design, installation, operation and maintenance of machinery and equipment used within a bakery. Specific equipment covered in this checklist include: bag chutes and bag lifts; dumpbins and blenders; and ovens. Questions marked with the symbol (E) may require the help of an outside expert.

This checklist does not address: general requirements for flour-handling systems; flour storage bins; flour screw conveyors; flour sifters; and flour scales. Consult 29 CFR 1910.263 for the regulations dealing with these types of equipment.

Flour-handling Equipment	<u>Please Circle</u>
1. Are bag chutes (gravity chutes for handling flour bags) so designed as to keep to a minimum the speed of flour bags? [29 CFR 1910.263(d)(2)(i)]	Y N N/A DK
Note: If the chute inclines more than 30 degrees from the horizontal, there shall be an upturn at the lower end of the chute to slow down the bags.	

Comments/Corrective Action
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| 2. | Are all dumpbin and blender hoods of sufficient capacity to prevent circulation of flour dust outside the hoods? [29 CFR 1910.263(d)(3)(v)]                            | Y N N/A DK |
| 3. | Are all dumpbins of suitable height from the ground to enable the operator to dump the flour bags without causing undue strain or fatigue? [29 CFR 1910.263(d)(3)(vi)] | Y N N/A DK |
| 4. | Where the edge of any bin is more than 24 inches above the floor, is a bag rest provided? [29 CFR 1910.263(d)(3)(vi)]  | Y N N/A DK |
| 5. | Is there a control device with the operator's reach for stopping the dumpbin and blender? [29 CFR 1910.263(d)(3)(vii)]   | Y N N/A DK |


**Ovens**

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| 6. | Are emergency stop buttons provided on mechanical ovens near the point where the operator is stationed? [29 CFR 1910.263(l)(3)(I)]  | Y N N/A DK |
| 7. | Is all piping at the oven tested to be gas tight? [29 CFR 1910.263(l)(3)(ii)]   | Y N N/A DK |
| 8. | Are main shutoff valves, operable separately from any automatic valve, provided to permit turning off the fuel or steam in case of an emergency? [29 CFR 1910.263(l)(3)(iii)] | Y N N/A DK |
| 9. | Is the main shutoff valve so located that explosions, fire, etc. will not prevent access to these valves? [29 CFR 1910.263(l)(3)(iii)(a)]                                     | Y N N/A DK |

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| 10.   | Is the main shutoff valve locked in the closed position when operators must enter the oven or when the oven is not in service? [29 CFR 1910.263(l)(3)(iii)(b)]   | Y N N/A DK |
| 11.   | Is a main disconnect switch or circuit breaker provided for electrical heating equipment? [29 CFR 1910.263(l)(8)(iii)]   | Y N N/A DK |
| 12.   | Is this switch or circuit breaker so located that it can be reached quickly and safely? [29 CFR 1910.263(l)(8)(iii)]   | Y N N/A DK |
| 13.   | Does the main switch or circuit breaker have provisions for locking it in the open position if any work on the electrical equipment or inside the oven must be performed? [29 CFR 1910.263(l)(8)(iii)]   | Y N N/A DK |
| 14.   | Are all protective devices properly maintained and kept in working order? [29 CFR 1910.263(l)(9)(I)]   | Y N N/A DK |
| 15.  | Are all safety devices on ovens inspected at intervals of not less than twice a month by an especially appointed, properly instructed person, and not less than once a year by representatives of the oven manufacturers? [29 CFR 1910.263(l)(9)(ii)]                  | Y N N/A DK |
| 16.   | Is protection of the gas pilot light provided when it is impracticable to protect the main flame of the burner and where the pilot flame cannot contact the flame electrode without being in the path of the main flame of the burner? [29 CFR 1910.263(l)(9)(iii)(a)] | Y N N/A DK |

Note: Failure of any gas pilot shall automatically shutoff the fuel supply to the burner.

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| 17. | Are ovens with multiple burners equipped with individual atmospheric pilot lights where there is sufficient secondary air in the baking chamber where gas is available; or else, each burner is required to be equipped with an electric spark-type ignition device? [29 CFR 1910.263(l)(9)(iii)(b)] | Y | N | N/A | DK |
| 18. | When fuel is supplied and used at line pressure, are safety shutoff valves provided in the fuel line leading to the burner? [29 CFR 1910.263(l)(9)(v)]   | Y | N | N/A | DK |
| 19. | When fuel is supplied in excess of line pressure, are safety shutoff valves provided in the fuel line leading to the burners? [29 CFR 1910.263(l)(9)(v)(a)]  | Y | N | N/A | DK |
- Note: The fuel supply lines may be equipped with other automatic valves which will prevent the flow of fuel when the compressing equipment is stopped.
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| 20. | Is the safety shutoff valve positively tight and tested at least twice monthly? [29 CFR 1910.263(l)(9)(v)(b)]  | Y | N | N/A | DK |
| 21. | Does the safety shutoff valve require manual operation for reopening after it has closed, or is the electric circuit so arranged that it will require a manual operation for reopening the safety shutoff valve? [29 CFR 1910.263(l)(9)(v)(e)] | Y | N | N/A | DK |
| 22. | Is the manual reset-type safety shutoff valve so arranged that it cannot be locked in an open position by external means? [29 CFR 1910.263(l)(9)(v)(f)]  | Y | N | N/A | DK |
| 23. | Where blowers are used for supplying the air for combustion, is the safety shutoff valve interlocked so that it will close in case of air failure? [29 CFR 1910.263(l)(9)(v)(g)]   | Y | N | N/A | DK |

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| 24. | Where gas or electric ignition is used, does the safety shutoff valve close in case of ignition failure? [29 CFR 1910.263(l)(9)(v)(h)]  | Y | N | N/A | DK |
| 25. | On burners equipped with combustion safeguards, does the valve close in case of burner flame failure? [29 CFR 1910.263(l)(9)(v)(h)]   | Y | N | N/A | DK |
| 26. | Is one main, manually operated, fuel shutoff valve provided on each oven, and located closer to the source of the fuel than all other valves in the system? [29 CFR 1910.263(l)(9)(vi)]   | Y | N | N/A | DK |
| 27. | Is any space in an oven (except direct fired ovens) which could be filled with an explosive mixture, protected by explosion vents? [29 CFR 1910.263(l)(9)(viii)]  | Y | N | N/A | DK |
| 28. | Are explosion doors which have substantial weight attached by chains or similar means to prevent flying parts from injuring people in case of an explosion? [29 CFR 1910.263(l)(9)(viii)(a)]  | Y | N | N/A | DK |
| 29. | Where explosion vents are so located that flying parts or gas might endanger people on or near the oven, are internal or external means provided in the form of heavily constructed shields or deflectors made from noncombustible material? [29 CFR 1910.263(l)(9)(viii)(b)] | Y | N | N/A | DK |
| 30. | Where the gas supply pressure is substantially higher than that at which the burner oven is designed to operate, is a gas pressure regulator employed? [29 CFR 1910.263(l)(9)(xi)]  | Y | N | N/A | DK |

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| 31.   | Is a relief valve placed on the outlet side of gas pressure regulators where gas is supplied at high pressure? [29 CFR 1910.263(l)(9)(xi)(d)]  | Y N N/A DK |
| 32.   | Are direct-fired ovens safeguarded against failure of fuel, air, or ignition? [29 CFR 1910.263(l)(10)(I)]  | Y N N/A DK |
| 33.   | Is each circulating fan in direct recirculating ovens interconnected with the burner in such a manner that the fuel is shutoff by a safety valve when the fan is not running? [29 CFR 1910.263(l)(11)(I)]                          | Y N N/A DK |
| 34.   | Is the flame of the burner or burners in direct recirculating ovens protected by a quick-acting flame-sensitive safeguard which will automatically shutoff the fuel supply in case of burner failure? [29 CFR 1910.263(l)(11)(ii)] | Y N N/A DK |
| 35.  | Are duct systems (in ovens) operating under pressure, tested for tightness in the initial starting of the oven and also at intervals of six months or less? [29 CFR 1910.263(l)(15)(iii)]  | Y N N/A DK |

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